

Date: Thursday, 05/03/2009 9:02:49 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BASKET BASE ASSEMBLY (350)		
Job Number	: 43785A			Part Number	: D2221	
Estimate Number	: 10189			Drawing Number	: D2221 REVG	
P.O. Number	:			Project Number	: N/A	
This Issue	: 05/03/2009		S.O. No. :	Drawing Revision	: G	
Prsht Rev.	: NC			Material	:	
First Issue	: 26/11/2008		Type :	Due Date	: 05/12/2008	
Previous Run	: 43779A			Qty:	1	Um: Each
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
		 Comment: LARGE FABRICATION RESOURCE 1 <ul style="list-style-type: none"> 1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235 2-Drill hole in D2221-3 as per Dwg D2221 3-Deburr 4-Remove all markings on material before welding 5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required
2.0	D22211	Rib
		 Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) <p>Rib batch: <i>B45938</i> → 1 <i>SL 09/03/05</i></p>
3.0	D22215	Rib
		 Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) <p>Rib batch: <i>B46082</i> → 2 <i>SL 09/03/05</i></p>

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Job Number: 43785A

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 D22217 Rib



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib

batch: B 46083 → 1x

SL 09/03/05

5.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

batch: B 42075 → 1x B 46084 → 1x

SL 09/03/05

6.0 D22351 Basket Rib



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Rib

batch: B 46085 → 2x

SL 09/03/05

7.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

batch: B 43800 → 2x

SL 09/03/05

8.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

batch: B 45226 → 2x

SL 09/03/05

9.0 D3825041 Rib Assembly (Basket End)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib Assembly (Basket End)

batch: B 46087 → 2x

SL 09/03/05

10.0 D3826041 Rib / Gusset Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Rib / Gusset Assembly

batch: B 46088 → 2x

SL 09/03/05

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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 D3827041 Rib Assembly (Inboard)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rib Assembly (Inboard)

batch: B45609 → 1x

SL 09/03/09

12.0 D38331 Mesh (Base End Face)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mesh (Base End Face)

batch: B45896 → 2x

SL 09/03/09

13.0 D38321 Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B45944

SL 09/03/09

14.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 M

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221 M

3- tack weld mesh on basket as per dwg D2221 M

A/R ER316 S.S. Rod Batch: M108775

SL 09/03/09 1x

15.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-03-11

16.0 QC6 DIMENSIONAL CHECK



SL 09-03-11



Comment: DIMENSIONAL CHECK

17.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

M110939
Pressure wash M/BR 09-03-11

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

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Job Number: 43785A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

~~1910~~

Description :

1ST COAT:

START TIME:

14:15

OVEN TEMPERATURE:

400°

FINISH TIME:

14:45

***** 2nd coat if necessary*****

LMO/BL

09/03/11

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M1



09-03-12

X1

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

QC21

FINAL INSPECTION/W/O RELEASE



①

Comment: FINAL INSPECTION/W/O RELEASE

109/03/11

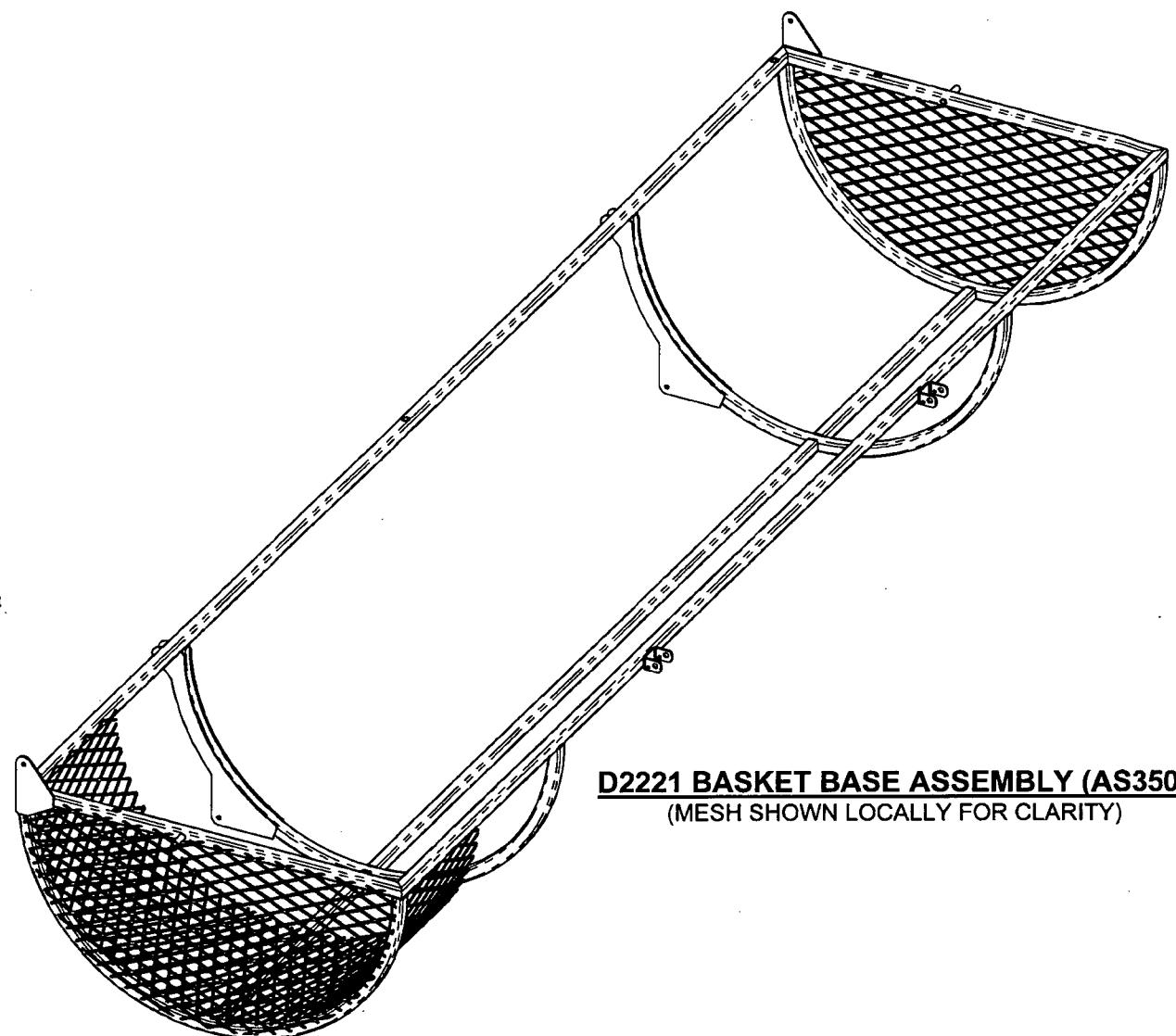
mf 09-03-13

Job Completion



8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	✓		
CHECKED	✓	DRAWING NO.	REV. H
MFG. APPR.	✓	D2221	SHEET 1 OF 5
APPROVED	✓	TITLE	SCALE
DE APPR.	✓	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

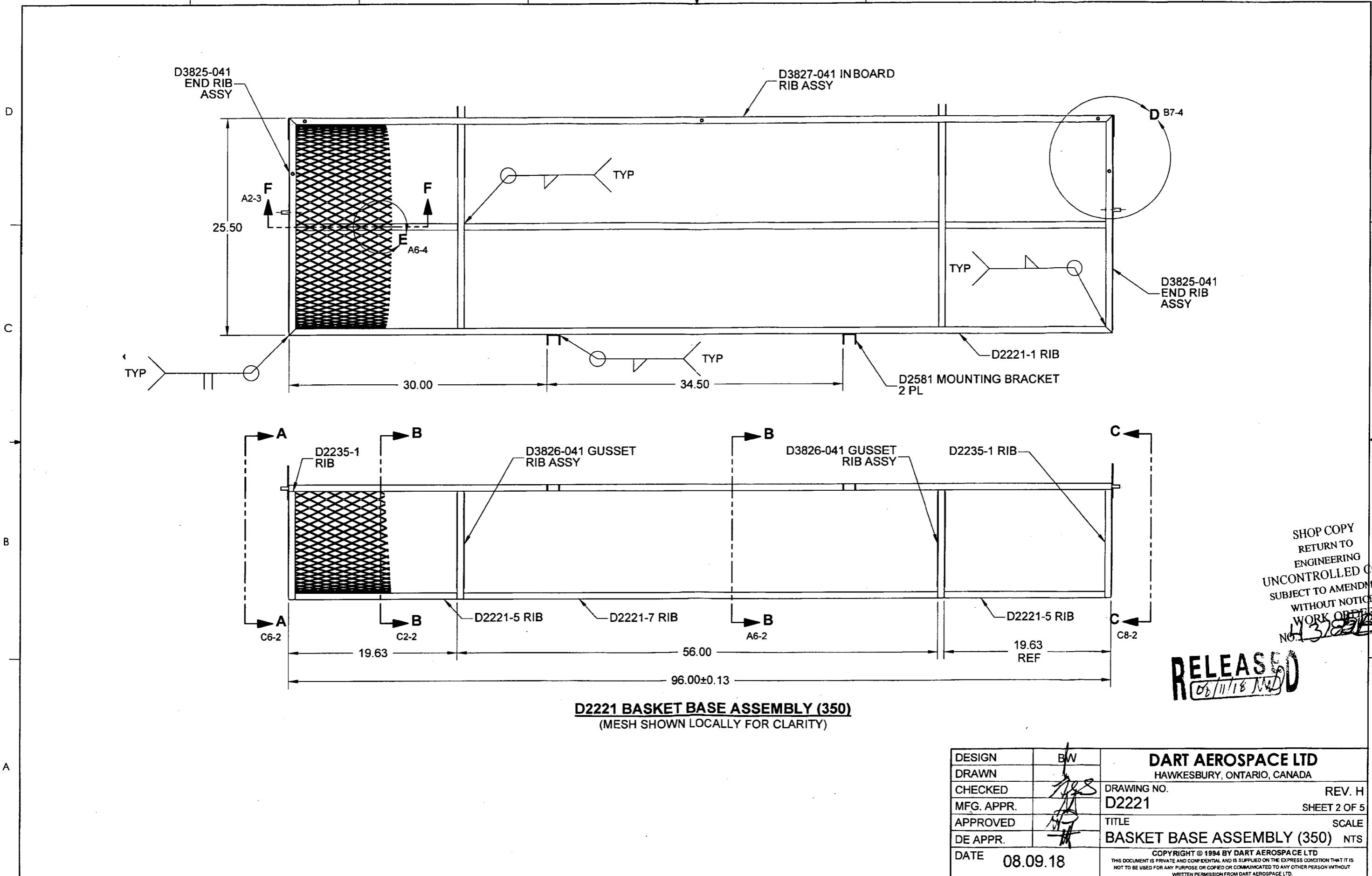
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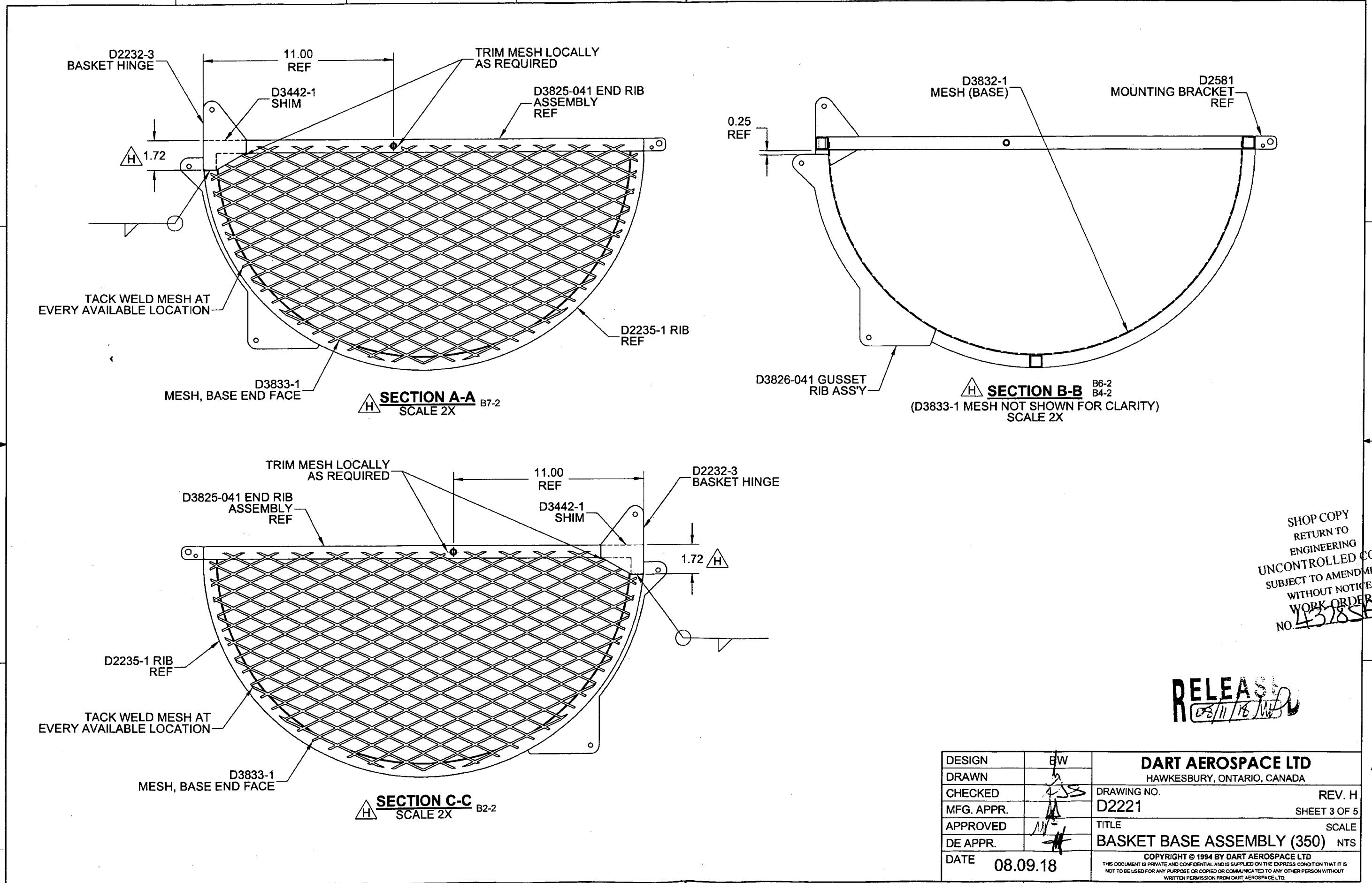
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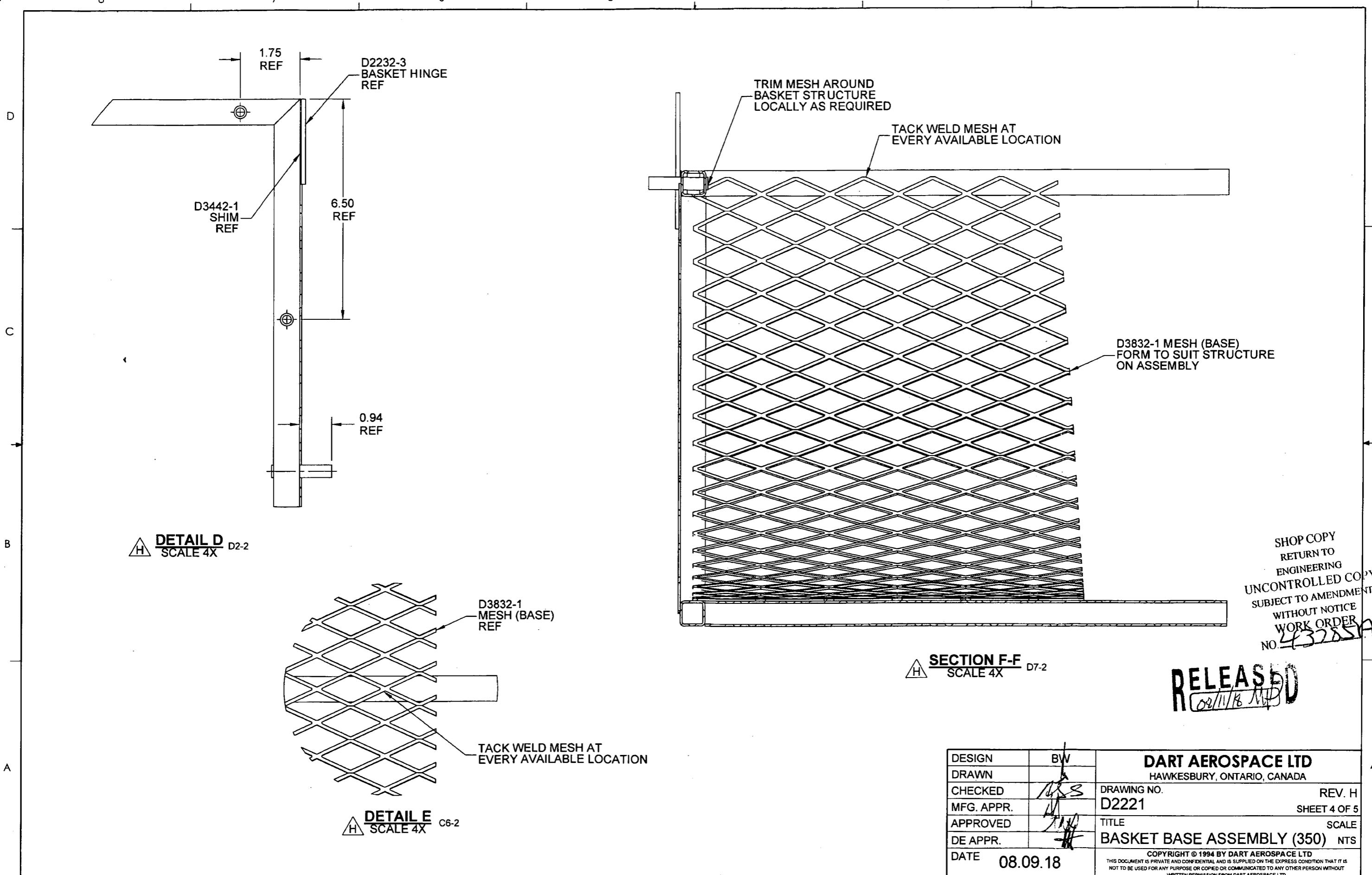
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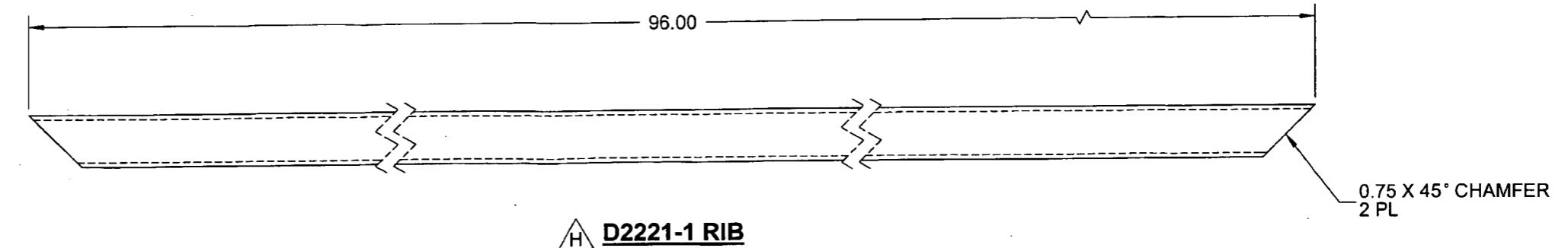
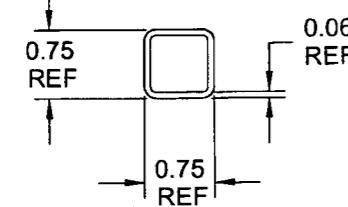




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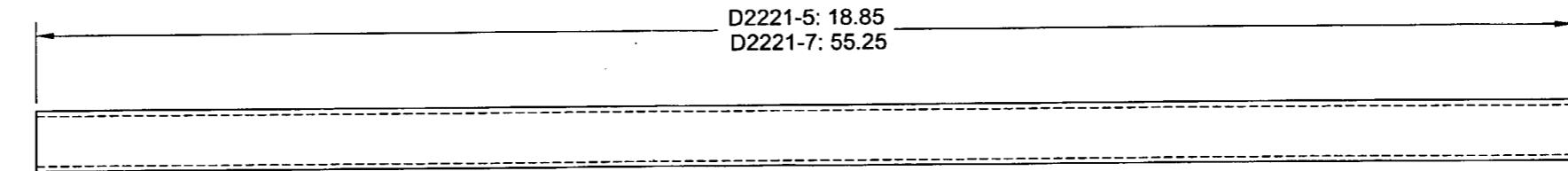
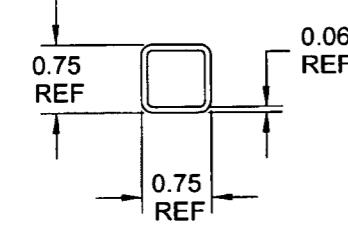
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△ **D2221-1 RIB**

C

C



△ **D2221-5/-7 RIB**

B

B

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08/11/18 M

NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 = 2.65 lbs

DESIGN	BW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. H
MFG. APPR.	NO	D2221 SHEET 5 OF 5
APPROVED	W	TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD

8

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4

3

2

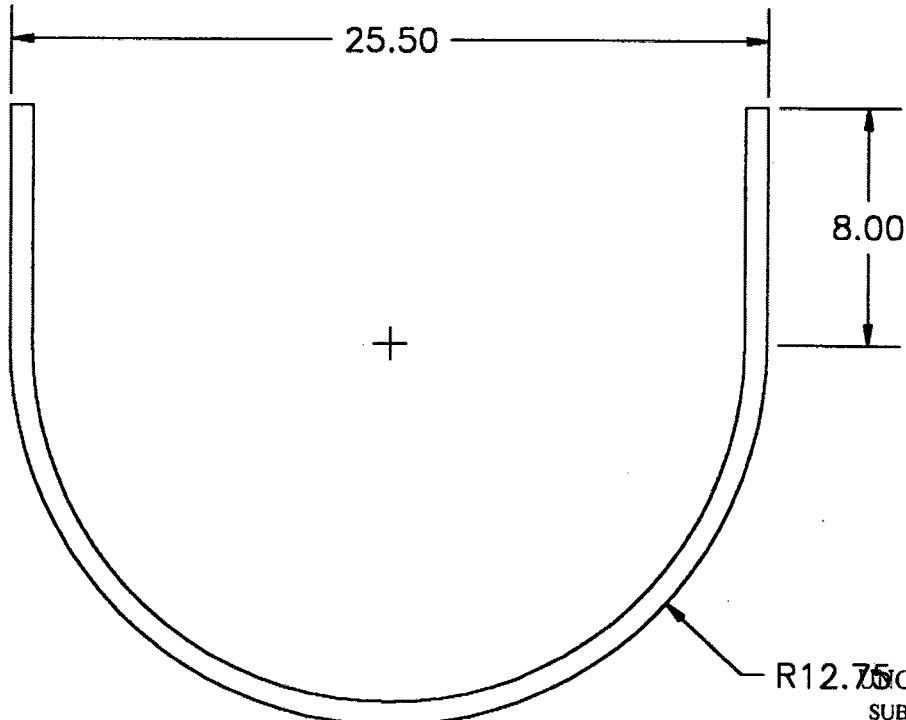
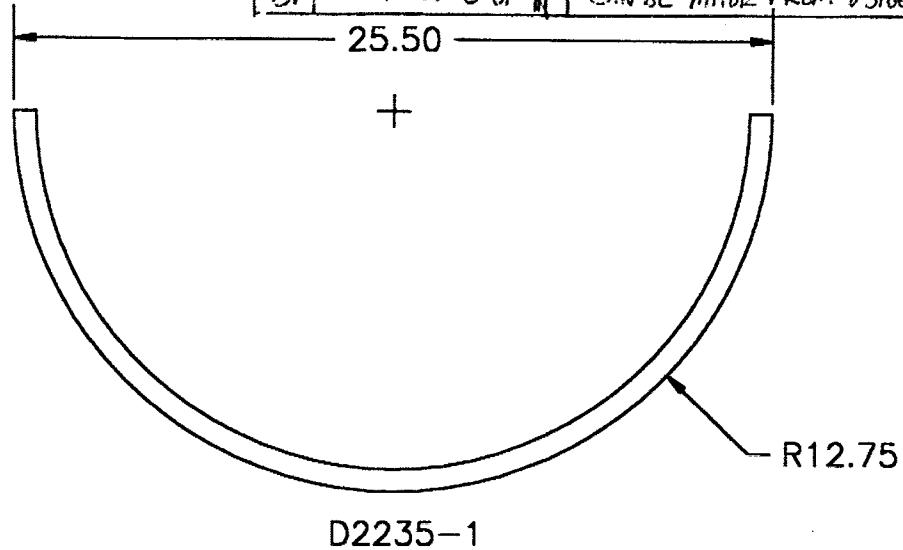
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A

DART

DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Sw</i>	APPROVED <i>BW</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE

B1 02.08.06 (P-1) CAN BE MADE FROM D3166-1

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R 960507

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CAN BE MADE FROM D3166-1 (B1)
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.